

Work Order ID 147233

June 08, 2016 11:50:43 AM

147233

Please cut today

Wed.
June 8.

Page 1

Item ID: D3891-4

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Gasket

Stop

NS2

Start Date: 6/9/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/10/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: SH

Date: 6/8/16

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3891

A

100

0.00

100

Waterjet

Memo

0.04

FLOW CNC Waterjet

1-Cut as per Dwg D3891

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.01

Quality Control

PR/06/08/2016

4

4

PR/16/06/09

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval			
Description Work Order Deviation				Disposition				Completed By			
								Lead hand / Supervisor Approval Verification			
								QC / QA Coordinator Approval			
Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
				OTHER : ☐							

Work Order ID 147233

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147233

Page 2

Item ID: D3891-4

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Gasket

Stop ***NS2***

Start Date: 6/9/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/10/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.01

Quality Control

(4)

DAS
38
9-89

JUN 09 2016

130

Identify as per dwg & Stock Location: 54508A

0.00

130

Packaging

Memo

0.01

Packaging

4

DAS
6
9-89

JUN 09 2016

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.07

Quality Control

HJ / R. J. 16.06.16

MCS JUN 10 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
						QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 1

Work Order ID: 147233

147233

Parent Item: D3891-4

D3891-4

Parent Item Name: Gasket

Start Date: 6/9/2016

Required Date: 6/10/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4111NS.125		Purchased		No		100	sf	240.1770	2.963	12.47579			

M4111NS 125

4111 Black Neoprene/EPDM/SBR Blend Sheet 0.125"

206/07/2016

Location

Loc Qty

Loc Code

MAT052

240.177

m130068

15.177

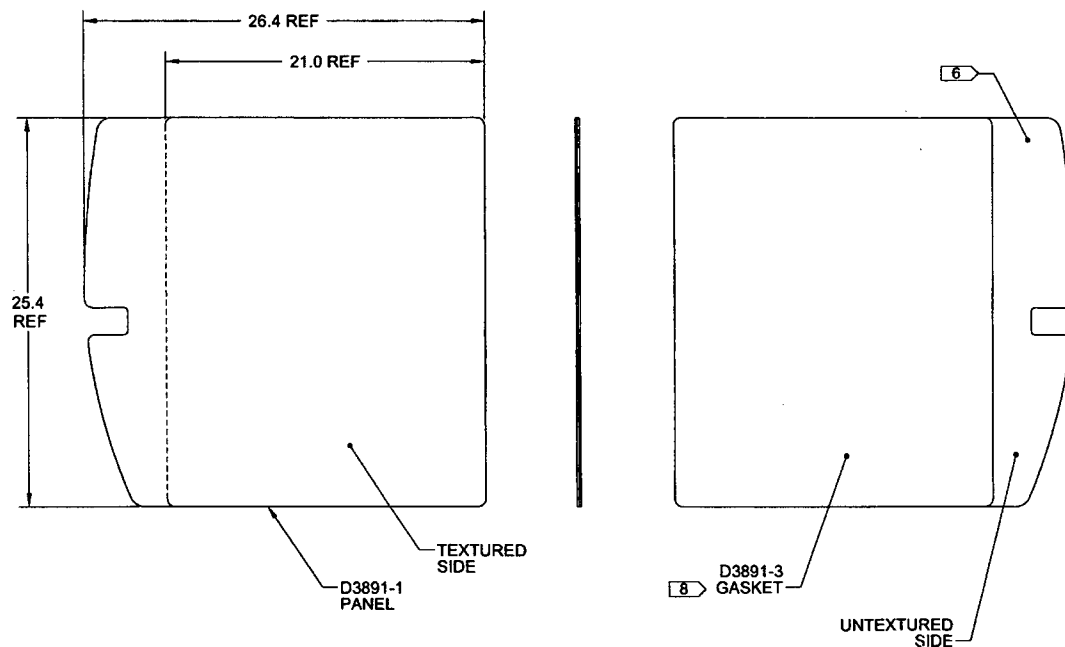
m134321

225

12.2

PARTS LIST

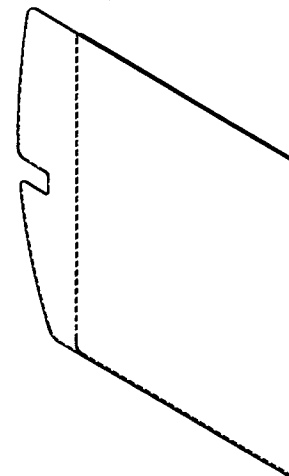
ITEM	QTY	P/N	DESCRIPTION
1	X	D3891-041	PANEL, FWD LH
2	1	D3891-1	PANEL
3	1	D3891-3	GASKET
4	A/R	3M 1300	ADHESIVE



D3891-041 PANEL, FWD LH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3891-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 3.67 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.



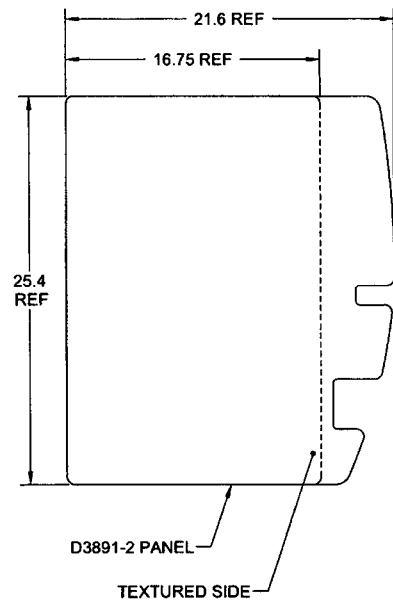
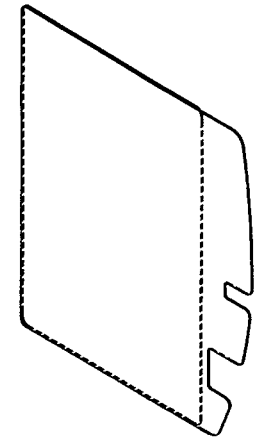
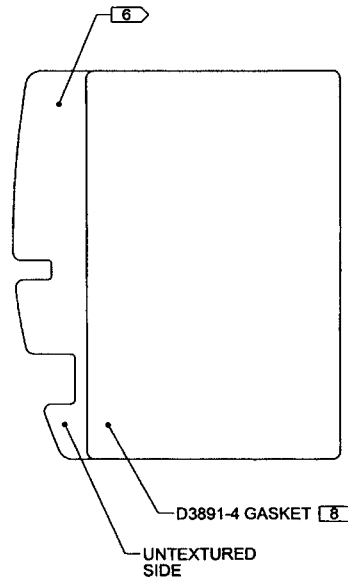
RELEASED
C9/06/16

6/8/16
SH 147233

A	NEW ISSUE	CP	09.05.01
REV.	DESCRIPTION	BY	DATE
DESIGN	GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	GP		
CHECKED	RS	DRAWING NO.	REV. A
MFG. APPR.	JS	D3891	SHEET 1 OF 6
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	PANEL, FWD	NTS
DATE	09.05.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

PARTS LIST

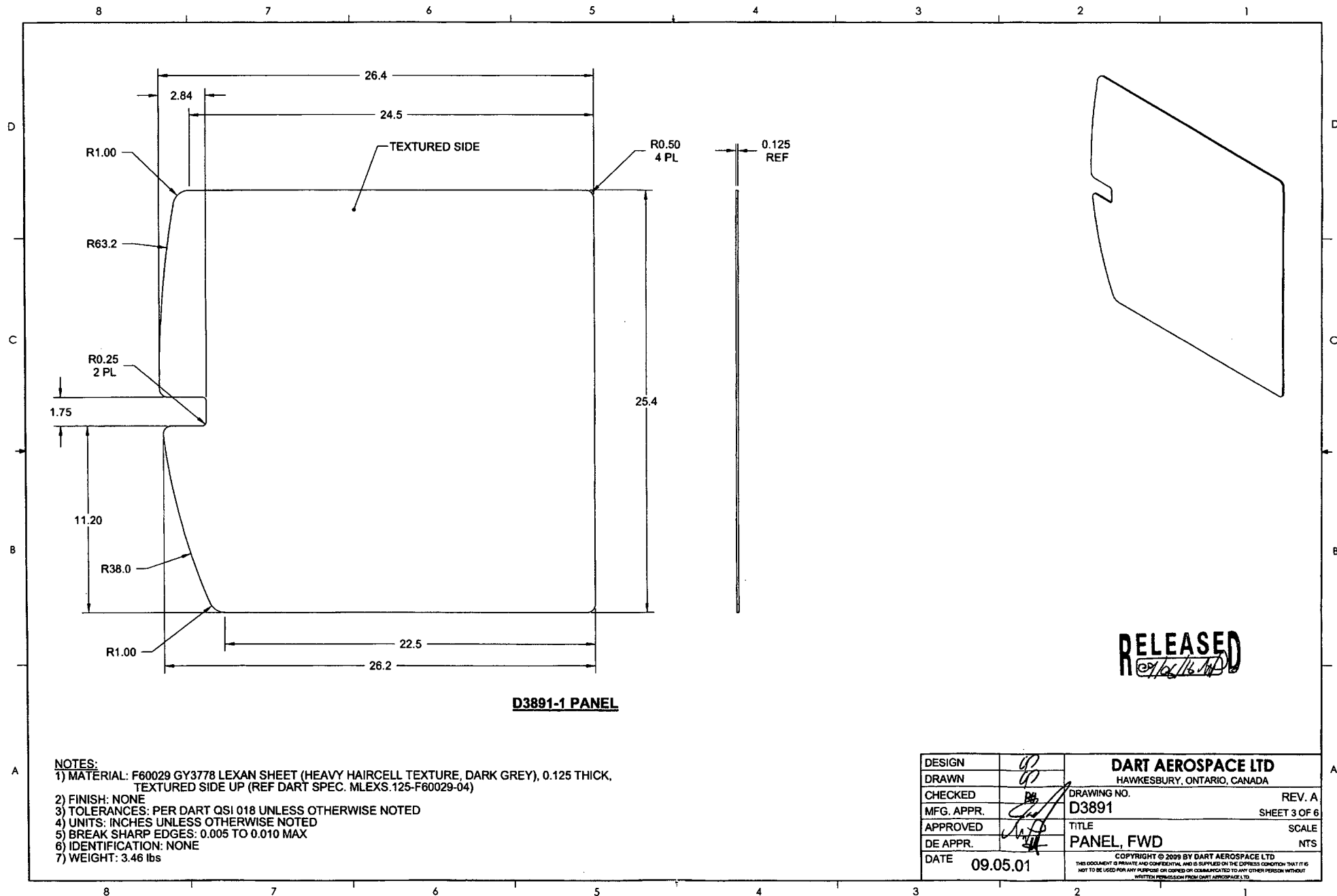
ITEM	QTY	P/N	DESCRIPTION
1	X	D3891-042	PANEL, FWD RH
2	1	D3891-2	PANEL
3	1	D3891-4	GASKET
4	A/R	3M 1300	ADHESIVE

**D3891-042 PANEL, FWD RH**

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3891-042" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 2.93 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.

DESIGN	GP	DART AEROSPACE LTD	
DRAWN	GP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PL	DRAWING NO.	REV. A
MFG. APPR.	SL	D3891	SHEET 2 OF 6
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DE APPR.	AM	PANEL, FWD	NTS
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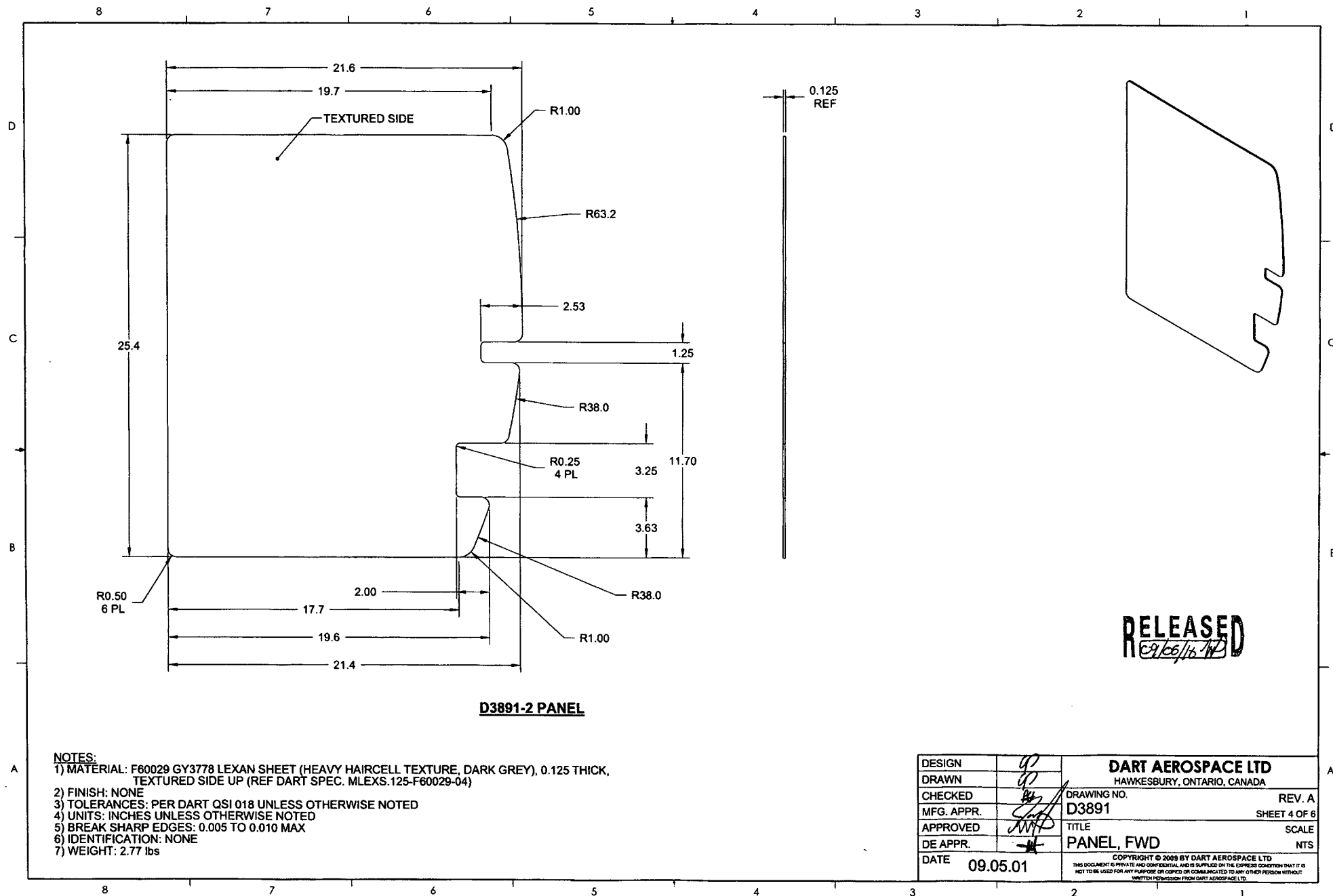


RELEASED

NOTES:

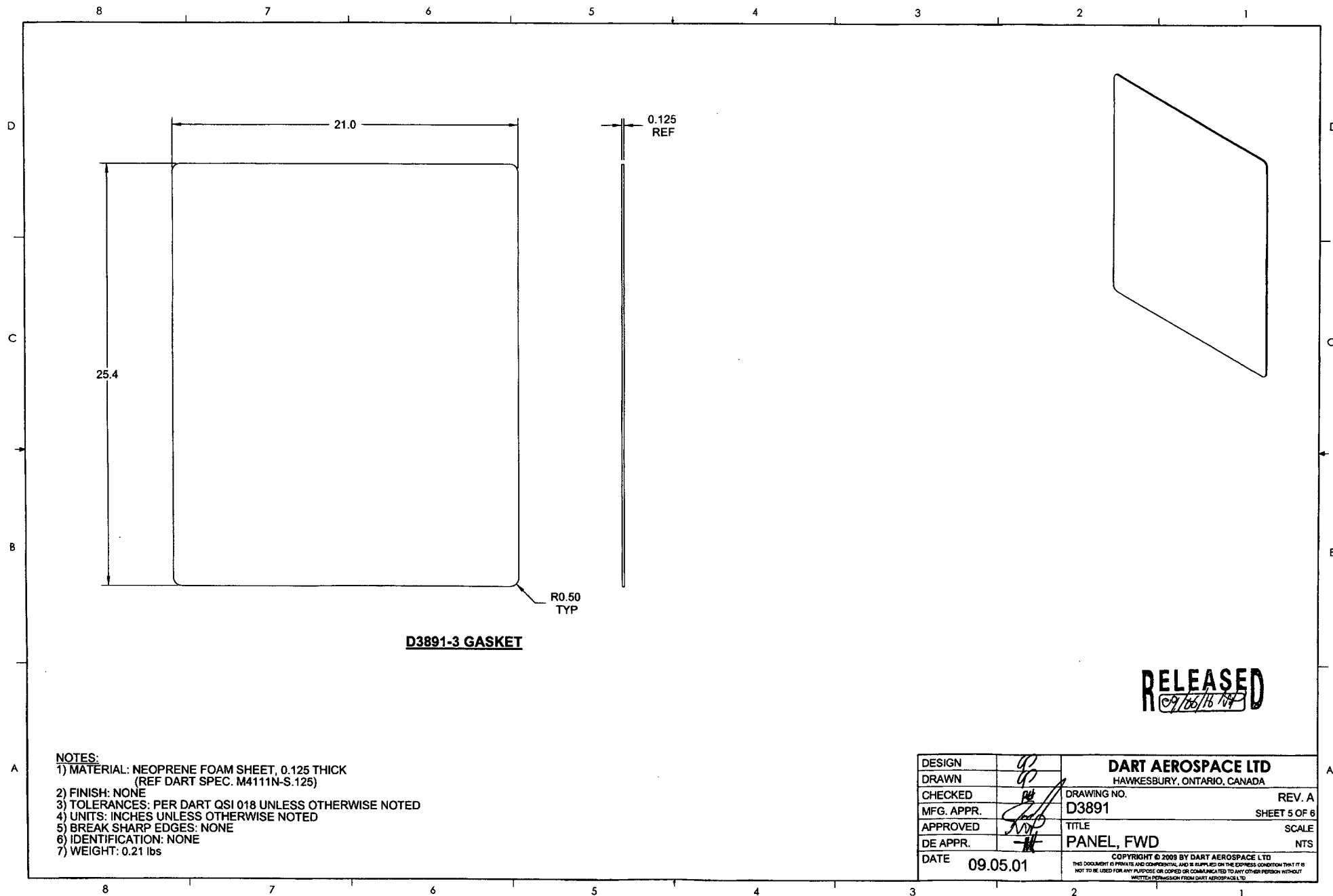
- 1) MATERIAL: F60029 GY3778 LEXAN SHEET (HEAVY HAIRCELL TEXTURE, DARK GREY), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC. MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 3.46 lbs

DESIGN	<i>JP</i>	DART AEROSPACE LTD	
DRAWN	<i>JP</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>DB</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3891	SHEET 3 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	PANEL, FWD	NTS
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09/05/01

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DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	92	DRAWING NO.	REV. A
MFG. APPR.	92	D3891	SHEET 4 OF 6
APPROVED	92	TITLE	SCALE
DE APPR.	92	PANEL, FWD	NTS
DATE	09.05.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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NOTES:

- 1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK
(REF DART SPEC. M4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.21 lbs

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DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	92	DRAWING NO.	REV. A
MFG. APPR.	92	D3891	SHEET 5 OF 6
APPROVED	92	TITLE	SCALE
DE APPR.	92	PANEL, FWD	NTS
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